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(54) Recycling of grinding sludge in the form of briquettes

(57) A method of and an apparatus for compressing the grinding sludge, which is effective to compress the grinding sludge to provide an intended rigid briquette even though the grinding sludge contains ground chips of hardened iron and/or steel materials and an oil-based coolant and also to facilitate reuse of the briquette (B1) as material for production of steel. The grinding sludge containing the oil-based coolant and hardened component parts such as steel component parts that are used

in bearings is compressed. To this end, the grinding sludge produced from a grinding line (1) is filtered by a filtering unit (4) to provide a concentrated sludge which is subsequently compressed by squeezing by a briquetting machine (5) to provide the briquette (B1). The briquette B1 so obtained can be reused as steel material. The coolant separated from the grinding sludge during filtering and squeezing is returned to the grinding line (1) through recovery passages (7, 8).

Fig. 1A

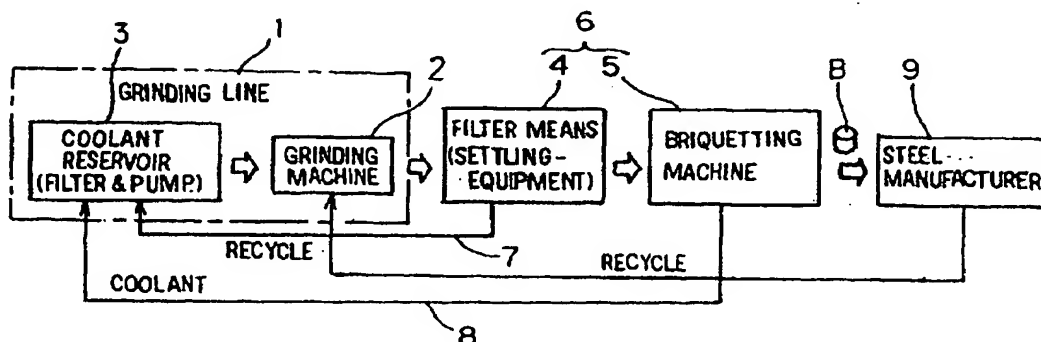
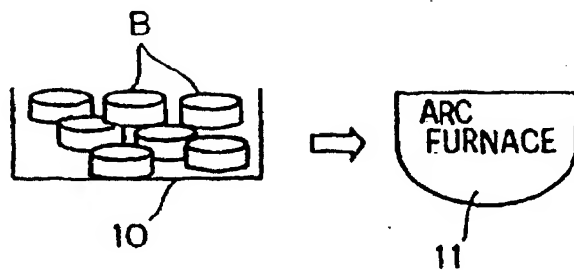


Fig. 1B





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The present search report has been drawn up for all claims			
Place of search <b>THE HAGUE</b>		Date of completion of the search <b>1 August 2002</b>	Examiner <b>Bombeke, M</b>
CATEGORY OF CITED DOCUMENTS X: particularly relevant if taken alone Y: particularly relevant if combined with another document of the same category A: technological background O: non-written disclosure P: intermediate document		T: theory or principle underlying the invention E: earlier patent document, but published on, or after the filing date D: document cited in the application L: document cited for other reasons &: member of the same patent family, corresponding document	

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